

Work Order ID 71203

Thursday, June 23, 2011 1:12:47 PM



Page 1

Item ID: D3453-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: AMF Date: 11-06-23

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3453

Rev A

100

0.00



Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA577

Rev: AK

Dwg D3453 Rev: B

2- Deburr as per dwg D3453

29 11.6.28

4

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

29 11.6.28

4

160

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

29 11.6.29

4

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

6/24/30 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/24/30 (4)

6/11-06-30 (4)

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Picklist Print

Thursday, June 23, 2011 1:12:45 PM

Page 1

Work Order ID: 71203

Parent Item: D3453-1

Parent Item Name: Clevis



Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: A 05.09.27 New issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250 		Purchased	No			100	f	49.3300	0.288	1.152		11.6.28	
304 round bar 1.250													

Location

Loc Qty

Loc Code

MAT029

49.33

105872 ✓

12.33

108156 ✓

12.33

111018 ✓

24.67

1.5

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 71203
Description: Clevis		Part Number: D3453-1
Inspection Dwg: D3453	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.441	/		RE .02	
R0.25	+/-0.030	R.25	/			
0.450	+/-0.010	.453	/			
0.625	+/-0.010	.625	/			
0.063 x 45°	+/-0.010 x 0.5°	.065	/			
Ø0.129	+0.005/-0.001	.128	/			
			/			
3.26	+/-0.030	3.264	/		RE .02	
1.00	+/-0.030	1.000	/			
1.550	+/-0.010	1.580	/			
0.500	+0.010/-0.000	.504	/			
0.263 x 45°	+/-0.010 x 0.5°	.270 x 45°	/			
R0.25	+/-0.010	.25	/			
			/			
Ø1.13	+0.012/-0.001	1.125	/			+/- .030
Ø0.500	+0.000/-0.005	.497	/		RE .02	

Measured by: R	Audited by: SA	Prototype Approval:	N/A
Date: 11.5.29	Date: 11/6/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	
C	08.10.09	Diameter symbol removed from 0.500 dimension	KJ/DD	
D	09.11.04	Dimensions updated per Dwg Rev B	KJ	

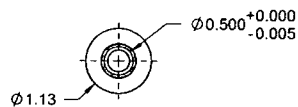
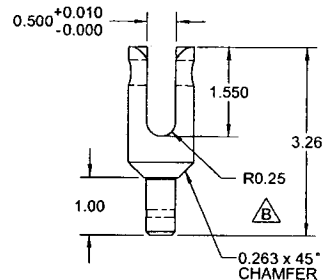
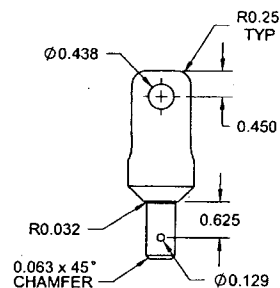
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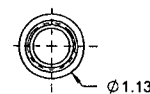
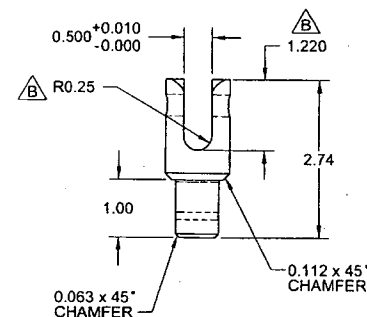
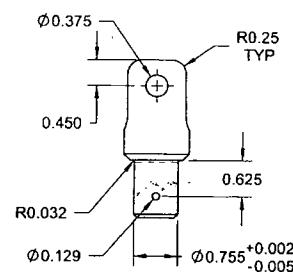
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D3453-1 CLEVIS



D3453-3 CLEVIS

RELEASED
9/6/25 MPD

D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018		RF	09.05.21
A	NEW ISSUE		RF	05.09.02
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3453 TITLE CLEVIS SCALE NTS		
DRAWN	RF			
CHECKED	RF			
MFG. APPR.	RF			
APPROVED	RF	DATE	09.05.21	REV. B SHEET 1 OF 2
DE APPR.	RF	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE FIRM'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

71203

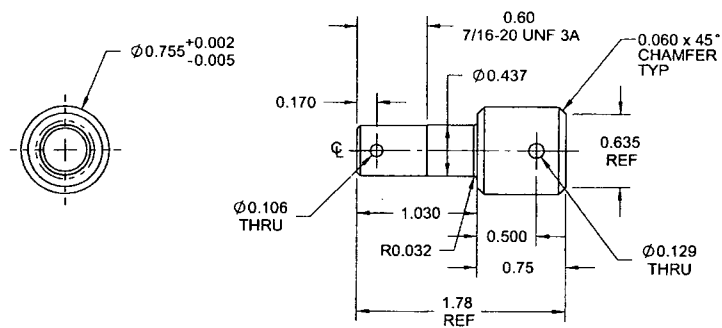
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NOTE: Date & initial all entries



D3453-5 PLUG

71203

RELEASED
01/25/11

D3453-5 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3453	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLEVIS	NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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